

Work Order ID 85813

June-15-12 1:27:01 PM

85813

Page 1

Item ID: D2022-103

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 15/06/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/15

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2022	Rev ...

100 0.00

100

Hardinge

Hardinge CNC Lathe Small

Memo

0.00

Note: .323" dia drill
1-Turn as per folio FA207 & dwg
FOLIO REV: AA
DWG REV: N/A

2-Deburr as required

12/07/04

60

Ø

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

12/07/04

60

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 60.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 003

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

52 12714

60

60

12/07/04 JB

12/7/5 JD

MF

12-07-04

Dart Aerospace Ltd

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Picklist Print

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Parent Item: D2022-103

D2022-103

Parent Item Name: Spacer

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A 11.05.11 new DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	80.5000	0.0189	1.193684			
M6061T6R0 750									**	1.900'		12/07/04	
6061-T6 Round Bar .750"													

Location

Loc Qty

Loc Code

MAT012

6.5

120734

6.5

MAT013

74

→ 121282

14

122081

60

1.900'

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Dart Aerospace Ltd

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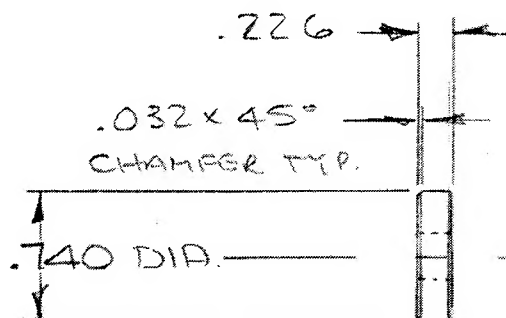
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RELEASED
970119 BW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85813 MLJ

12/06/15



D2022-101
D2022-103

DRILL 'F' (.257) DIA. IN -101
DRILL 'P' (.323) DIA. IN -103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/8)



D2022

D2022-103	SPACER 5/16 ALUM 6061-T6	QQ-A-250/8
D2022-101	SPACER 1/4 ALUM 6061-T6	QQ-A-250/8

REVISION	DESCRIPTION	DATE	BY	APPROVED
1	SPACER 5/16 ALUM 6061-T6	12/06/15	BRADLEY	
2	SPACER 1/4 ALUM 6061-T6	12/06/15	BRADLEY	

CONTRACT NO.		DART AERO ACCESSORIES INC	
DESIGN	DATE	CLIENT	TITLE
BRADLEY	12/06/15		SPACERS
CHECKED		CODE	DWG. NO.
			D2022
CLIENT		SCALE	SHT 1 OF 1

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523	QTY. REQUIRED
DRAWN		BASIC CODE	APPROVAL
APPROVED		DIM. DASH NO. IN-HEAD NEAR SIDE	
		LENGTH DASH NO. IN-SPOTWELD	
		BASIC CODES	
		REPORT ALL DISCREPANCIES - DO NOT SCALE	

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